

Work Order ID 101988

May-22-13 10:50:21 AM

101988

Page 1

Item ID: D4773-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 5/22/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4773

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

② EL 13-5-29

120

0.00

120

Large Fab

Memo

0.00

Large Fab

1- Weld hardcoat on bars as per dwg

A/R 2059b hardcoat Batch#: M124842

2- Weld bar to wearplate as per dwg

A/R s.s. rod Batch#: M122357

3- Weld shim as per dwg

A/R s.s. rod Batch#:

4- Transfer drill drain holes as per dwg

② EL 13-5-29

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Item ID: D4773-041

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Setup Start *NS1*

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Required Date: 5/24/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									
QC	Memo	0.00				②	15-05-30		DAS 09 9-89
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				②	13-05-30		DAS 09 9-89
Quality Control									
150		0.00							
150									
Small Fab	Memo	0.00				2	0	0	AI 13-5-31
Small Fab	Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: <u>125226</u>								

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May-22-13 10:50:21 AM

Item ID: D4773-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/22/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				2			
160		0.00							
QC	Memo								
Quality Control		13.6 03							
170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170		0.00							
Packaging	Memo								
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180		0.00							
QC	Memo								
Quality Control									

2x f M 13/06/03

MCS 13-06-03

13-06-04

Picklist Print

May-22-13 10:50:20 AM

Page 1

Work Order ID: 101988

Parent Item: D4773-041

Parent Item Name: Wearplate Assembly

Start Date: 5/22/13

Required Date: 5/24/13

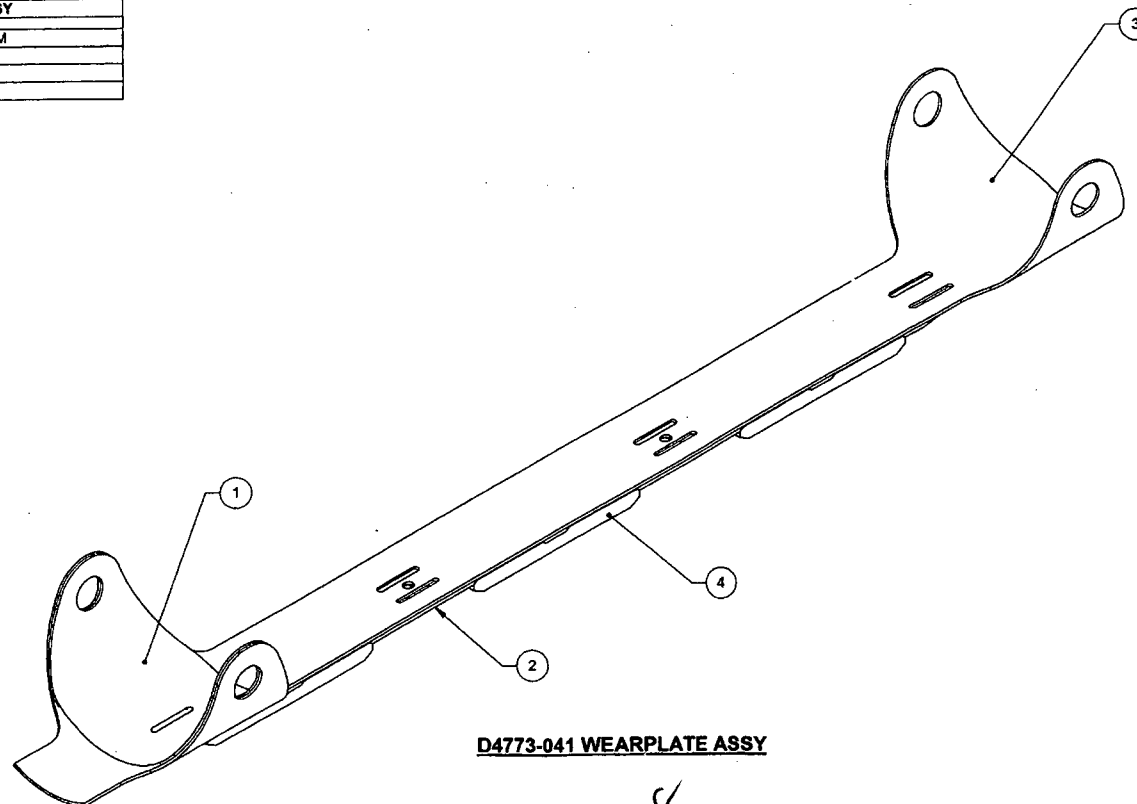
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4682-36 Wearplate		Manufactured	No	10060812			Each	0.0000		EL 2 13-5-29			
D4770-1 Bar		Manufactured	No	10199044			Each	0.0000		EL 4 13-5-29			
D4773-1 Wearplate		Manufactured	No	10199112			Each	0.0000		EL 2 13-5-29			

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4773-041	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE SHIM
2	2	D4770-1	BAR
3	1	D4773-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4773-041 WEARPLATE ASSY

w/o 10/10/88

RELEASED
2013-03-25
MP

A		NEW ISSUE		AP	13.02.13
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.			
DRAWN	AP	KENT, WA			
CHECKED	<i>GP</i>	DRAWING NO.	D4773	REV. A	
MFG. APPR.	<i>MS</i>			SHEET 1 OF 3	
APPROVED	<i>MS</i>	TITLE	WEARPLATE ASSY	SCALE	
DE APPR.	<i>MS</i>			NTS	
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR DISSEMINATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

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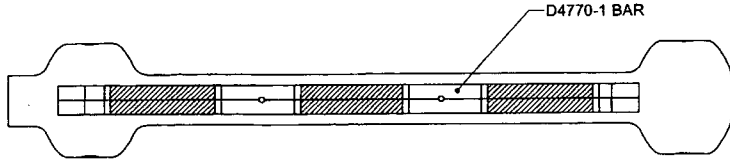
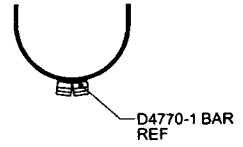
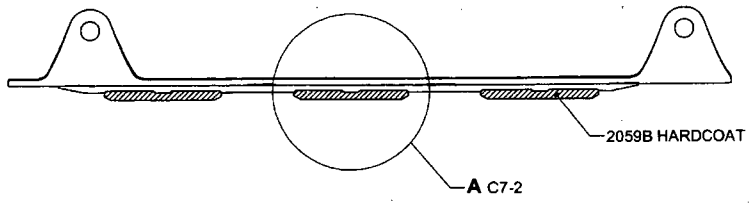
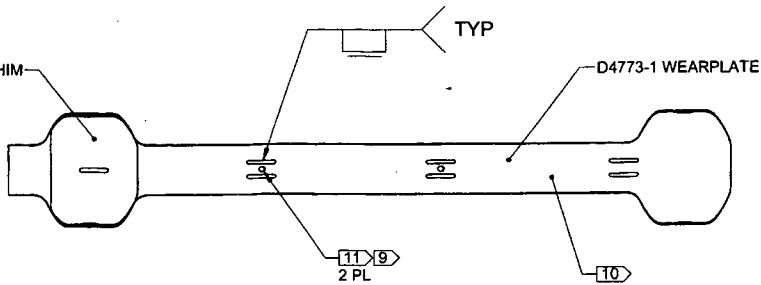
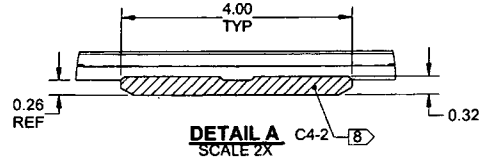
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D4773-041 WEARPLATE ASSY

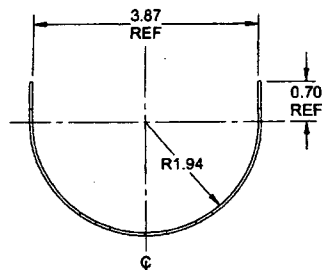
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11 2013-03-25
WV

NOTES:

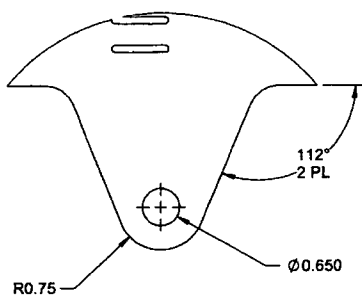
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4773-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.91 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL ϕ 0.188 HOLE FROM D4773-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO ϕ 0.188 AFTER APPLYING PLUS ONE ROCKGUARD

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	IS	DRAWING NO. D4773	REV. A
MFG. APPR.	IS	SHEET 2 OF 3	
APPROVED	IS	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	IS	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.	
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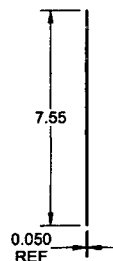
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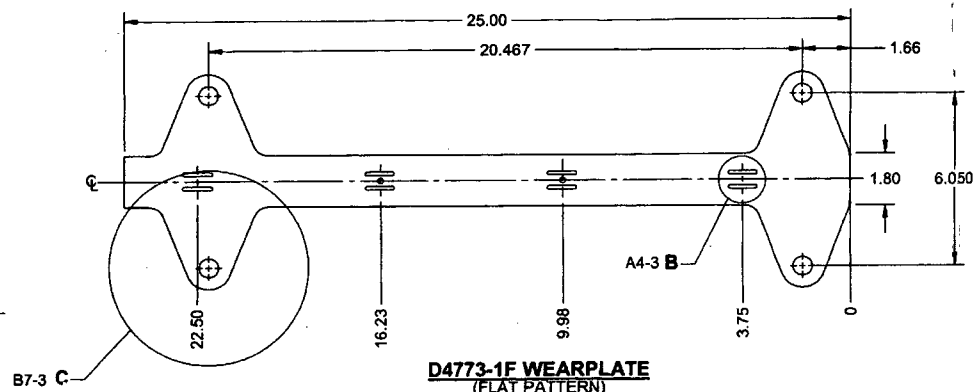
SECTION D-D D4-3 18
SCALE 2X



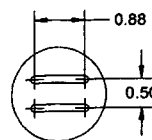
DETAIL C B4-3
4 PL
SCALE 2X



D4773-1 WEARPLATE
(MAKE FROM D4773-1F)



D4773-1F WEARPLATE
(FLAT PATTERN)



DETAIL B B2-3
4 PL
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4773-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

RELEASED
2013-03-25

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DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4773	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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